



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2938-2
Job Sheet 179300



Part No: D2938-2

Job Qty: 4 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Machining-1		1/48 18/8/12
100	CNC Vertical Machining	4 pcs	6/29/18	6/29/18	0.22	4.12	HAAS1-2		
110	Mill Conv	4 pcs	6/29/18	6/29/18	0.00	0.50	Mill Conv 1		
120	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC1		
130	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	4 pcs	6/29/18	6/29/18	0.00	0.18	HandFinish1		
150	Powdercoat	4 pcs	6/29/18	6/29/18	0.00	0.16	Powdercoat1		
160	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC3		
170	Packaging	4 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1	ST 395 98	
180	QC21-SA	4 Ea	6/29/18	6/29/18	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: 2:15 OUT 3:30 FINISH 2:45

M 38893

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

could not be found.

Plex 6/18/18 9:29 AM Dart.lajeunesse.marie

Dart Aerospace Ltd.
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Container No: S101273



Part: D2938-2

Job No: 179300

Serial No/Batch: S101273

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/11/18

1952 AUG 5 5018
1952 AUG 5 5018

DART AEROSPACE LTD	Work Order:	179300
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.129	0.129	0.128	0.130		
B	0.100	0.140		0.128	0.129	0.128	0.128		
C	0.100	0.140		0.125	0.125	0.123	0.123		
D	0.210	0.230		0.227	0.226	0.227	0.226		
E	1.245	1.255	✓	1.250	1.250	1.250	1.250		
F	1.245	1.255	✓	1.250	1.250	1.250	1.250		
G	2.495	2.505	✓	2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582	✓	1.577	1.577	1.577	1.577		
J	2.495	2.505	✓	2.500	2.500	2.500	2.500		
K	0.257	0.262	✓	0.257	0.257	0.257	0.257		
L	0.312	0.317	✓	0.313	0.313	0.313	0.313		
M	0.235	0.240		0.239	0.239	0.238	0.239		
N	0.100	0.140		0.118	0.120	0.119	0.119		
O	0.540	0.560		0.546	0.550	0.551	0.549		
P	0.490	0.510		0.500	0.501	0.500	0.500		
Q	3.715	3.725	✓	3.720	3.720	3.720	3.720		
R	2.720	2.760	✓	2.740	2.740	2.740	2.740		
S	0.240	0.270		0.264	0.265	0.264	0.264		
T	0.100	0.180		0.135	0.136	0.135	0.135		
U	1.625	1.635	✓	1.630	1.630	1.630	1.630		
V	1.362	1.372	✓	1.367	1.367	1.367	1.367		
W	0.316	0.321	✓	0.316	0.316	0.316	0.316		
X	1.250	1.270	✓	1.260	1.260	1.260	1.260		
Y	1.565	1.585	✓	1.575	1.575	1.575	1.575		
Z	0.178	0.198	✓	0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	

Audited by:	mmc
Date:	18/08/17

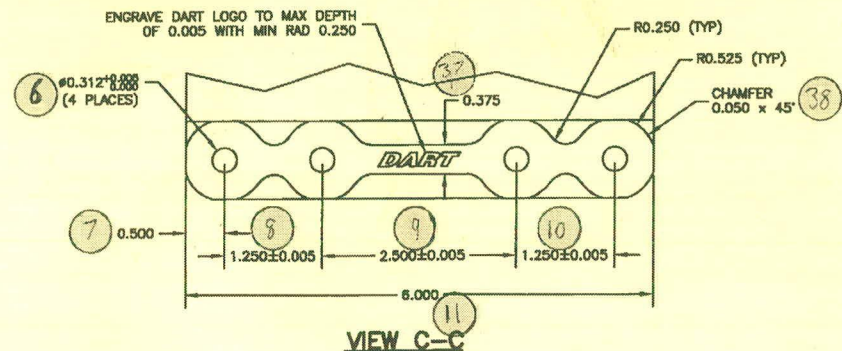
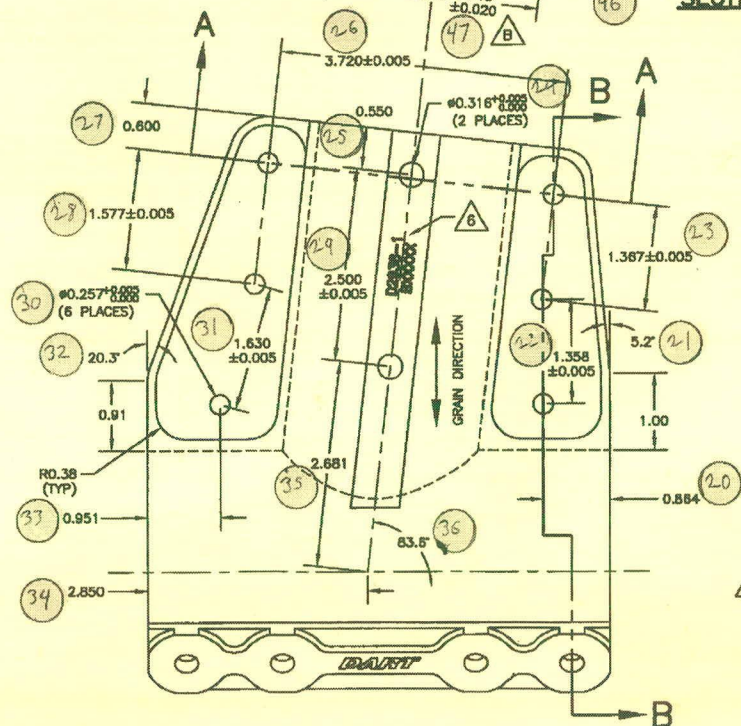
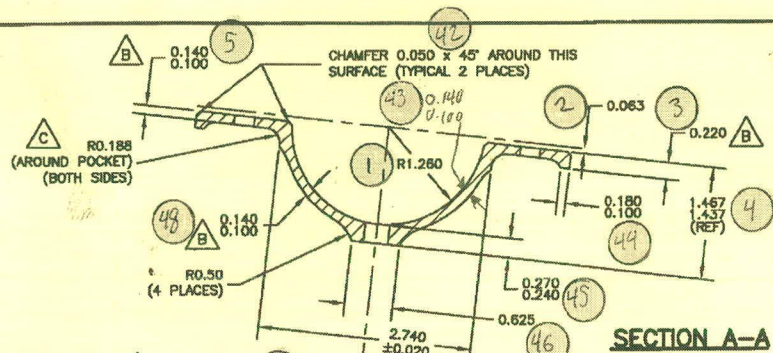
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		OTHER :							



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2938
SHEET 1 OF 1

REV. C

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : 	
Misidentified ☐	Past Due ☐																																																														